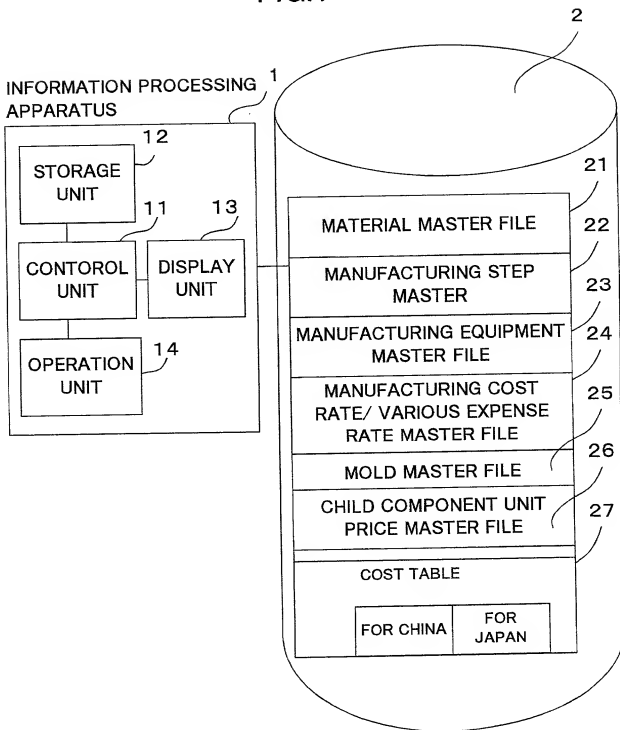


1/20
FIG.1



10029270.122801

2/20

FIG.2A

MATERIAL COST TABLE

MATERIAL NAME	BOARD THICKNESS	UNIT PRICE	DETAILS OF EXPENSE	OTHERS
SECC-C-E16/E16 (ZINC STEEL PLATE)	0.40	95.00	PLATE EXPENSE91.22 MANAGEMENT EXPENSE 3.78
	0.50	95.00
	0.60	94.00

AA1050P-H24	0.40	86.00

.....

10029270.122801

3/20 FIG.2B

MANUFACTURING EQUIPMENT COST TABLE

DEVICE NAME	PREPARAT ION TIME	PROCESSING TIME	UNIT PRICE/ HOUR
PRESS 90t	0.1	$1.3 + 0.1 \times L \times W \times T$
.....
MILLING MACHINE	0.2	$1.0 + 0.9 \times L \times W \times T$
.....

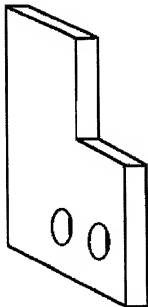
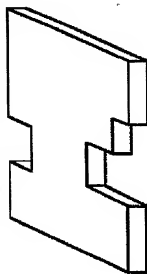
10029270-122801

4/20

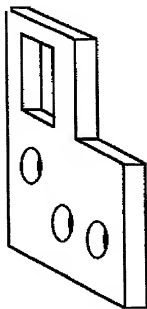
FIG.3

FORMING APPEARANCE PLUS PUNCHING

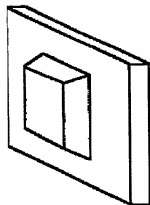
FORMING APPEARANCE



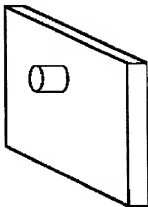
PUNCHING



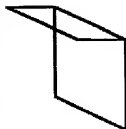
ONE TYPE OF EMBOSSING



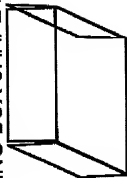
EMBOSSING



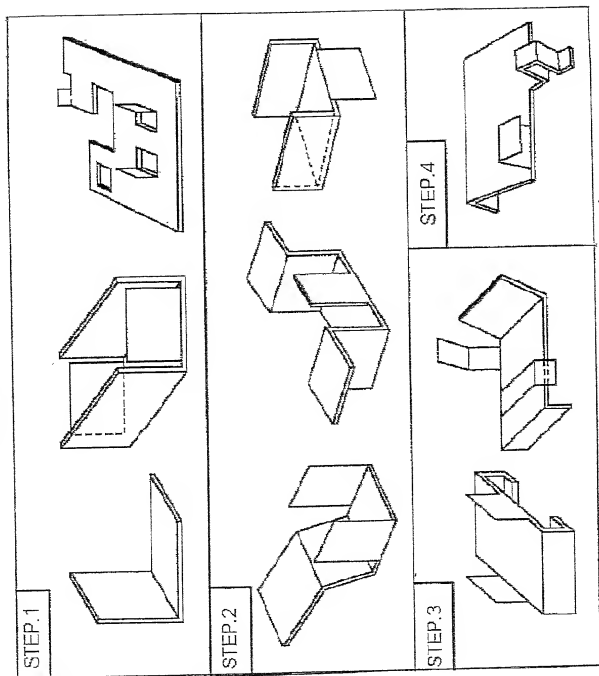
V-SHAPE BENDING



FORMING BOX SHAPE BY BENDING



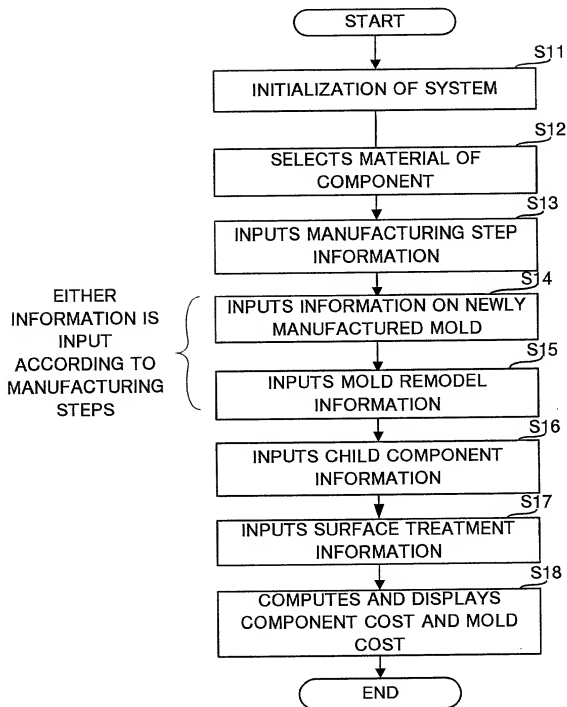
5/20
FIG.4



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6/20

FIG.5



7/20

FIG. 6

PRESS			
CODE NUMBER	SUFFIX		
KIND	NAME OF COMPONENT		
MENU			
UNIT PRICE OF COMPONENT	YEN	MATERIAL EXPENSE MANUFACTURING COST	YEN
		OTHERS	YEN
		(CHILD COMPONENT COST)	YEN
		PRIMARY MANUFACTURING COST	YEN
		SECONDARY MANUFACTURING COST	YEN
		MANUFACTURING STEP INFORMATION	YEN
		CHILD COMPONENT INFORMATION	YEN
		PROCESSING COST INFORMATION	YEN
		COMPUTATION OF MATERIAL HANDLING COST	YEN
		LIST OF COMPONENTS FOR COST COMPUTATION	YEN
		LIST OF MOLDS FOR COST COMPUTATION	YEN

COMPUTATION OF SUM TOTAL		COMPUTATION OF SUM TOTAL	
YEN		YEN	
NOT USE		TYPICAL MOLD	
MASTER DIE SET TYPE MOLD			

(BASIC DATA)	MONTHLY LOT	LOTS/MONTH	TOTAL LOT	LOTS
MATERIAL CODE	LIST	MATERIAL NAME	SPC SE	BOARD THICKNESS
MATERIAL FORM	SECURE NUMBER	mm		mm
EXTEND LENGTH	mm	EXTEND WIDTH	mm	OUTER CIRCUMFERENCE LENGTH

(MANUFACTURING STEP INFORMATION)			
NO.	NAME OF MANUFACTURING STEP	DESIGNATED COST CENTER	MANUFACTURING COST
1			
2			
3			
4			
MOLD COST			
REMODEL			

COMPONENT HARD TO HANDLE			
COMPUTATION RESERVE			

8/20
FIG.7

LIST OF MATERIALS



CLASSIFICATION BY MATERIAL NAME

A1050P-H54	▼
A15654-986	
A654-65908	
A654-986	
C654987-79	
.....	
.....	
.....	
.....	
.....	
.....	
.....	
.....	▲

OK



CLASSIFICATION BY MATERIAL CHARACTERISTIC

SPG1	▼
AL	
BL	
	▲

10029270-122801

9/20
FIG.8

LIST OF MATERIALS

CHARACTERISTIC OF MATERIAL

OK

NO.	MATERIAL NAME	BOARD THICKNESS	UNIT PLACE	SPECIFIC GRAVITY
1	DOK-v-g-b-/W-16(ZINC PLATE)	0.4	95	7.886
2	DOK-v-g-b-/W-16(ZINC PLATE)	0.5	95	7.886
3	DOK-v-g-b-/W-16(ZINC PLATE)	0.6	90	7.886
4	DOK-v-g-b-/W-16(ZINC PLATE)	0.7	90	7.886
5	DOK-v-g-b-/W-16(ZINC PLATE)	0.8	85	7.886
6	DOK-v-g-b-/W-16(ZINC PLATE)	0.9	85	7.886
7	DOK-v-g-b-/W-16(ZINC PLATE)	1	80	7.886
8	DOK-v-g-b-/W-16(ZINC PLATE)	1.1	80	7.886
9	DOK-v-g-b-/W-16(ZINC PLATE)	1.2	75	7.886
10	DOK-v-g-b-/W-16(ZINC PLATE)	1.3	75	7.886
11	DOK-v-g-b-/W-16(ZINC PLATE)	1.4	70	7.886
12	DOK-v-g-b-/W-16(ZINC PLATE)	1.5	70	7.886

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10029270-122801

10/20

FIG. 9

INFORMATION ON COST OF NEW MOLD			
EXTEND LENGTH	200 mm	EXTEND WIDTH	100 mm
		EXTEND OUTER CIRCUMFERENCE LENGTH	600 mm

(DATA FOR BOX-SHAPE BENDING)			
OUTER LENGTH	650 mm	OUTER CIRCUMFERENCE LENGTH	1420 mm
NUMBER OF CORNER R	3	SUM OF LENGTH AND WIDTH	710 mm

(BENDING PATTERN)			
FOR SURFACE BENDING	ONE TO TWO SURFACE BENDING	PARALLEL TWO SHAPE BENDING	OUTER CIRCUMFERENCE FLANGE EMBOSING

MANUFACTURING STEP		INPUT ITEMS			
BOX-SHAPE BENDING PLUS INTERNAL L-SHAPE BENDING	BENDING WIDTH	NUMBER OF POINTS TO BE PROCESSED			
1	5	1			
2	0	0			
BEAD LENGTH		NUMBER OF POINTS TO BE PROCESSED			
1	0	0			
2	0	0			
SQUARE SHAPE (CIRCLE SHAPE) EMBOSING		OUTER CIRCUMFERENCE LENGTH	EMBOSING DEPTH	NUMBER OF POINTS TO BE PROCESSED	
1	0	0	0	0	0
2	0	0	0	0	0
FLATTENING BY PRESSING (HOLE PORTION)		CIRCUMFERENCE LENGTH	NUMBER OF POINTS TO BE PROCESSED		
1	0	0	0	0	
2	0	0	0	0	

OUTER CIRCUMFERENCE FLANGE EMBOSING

SQUARE SHAPE (CIRCLE SHAPE) EMBOSING

11/20

FIG. 10

INFORMATION ON COST OF NEW MOLD			
EXTEND LENGTH <input type="text" value="200"/> mm	EXTEND WIDTH <input type="text" value="100"/> mm	EXTEND OUTER CIRCUMFERENCE LENGTH <input type="text" value="600"/> mm	

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(DATA FOR BOX-SHAPE BENDING)			
OUTER LENGTH <input type="text" value="654"/> mm	OUTER WIDTH <input type="text" value="56"/> mm	OUTER CIRCUMFERENCE LENGTH <input type="text" value="1420"/> mm	SUM OF LENGTH AND WIDTH <input type="text" value="710"/> mm
NUMBER OF POINTS TO BE BENT <input type="text" value=""/>			

(BENDING PATTERN)			
FOR SURFACE BENDING	THREE SURFACES	ONE TO TWO SURFACES	PARALLEL TWO SURFACES
<input type="radio"/> BENDING	<input type="radio"/> FACE BENDING	<input type="radio"/> SURFACE BENDING	<input type="radio"/> L-SHAPE BENDING
<input type="radio"/> BENDING <input type="radio"/> EMBOSSEMENT			

MANUFACTURING STEP		INPUT ITEMS			
NAME	BENDING WIDTH	NUMBER OF POINTS TO BE PROCESSED	LENGTH	WIDTH	NUMBER OF POINTS TO BE PROCESSED
BOX-SHAPE BENDING PLUS INTERVAL L-SHAPE BENDING	1	5	1		
	2	0	0		
BEAD	1	0	0		
	2	0	0		
SQUARE-SHAPE (CIRCLE-SHAPE) EMBOSSEMENT	1	0	0	0	0
	2	0	0	0	0
FLATTENING BY PRESSING (HOLE PORTION)	1	0	0	0	0
	2	0	0	0	0

L-SHAPE BENDING

OUTER CIRCUMFERENCE LENGTH
SUM OF LENGTH AND WIDTH

BOX-SHAPE BENDING PLUS INTERVAL L-SHAPE BENDING

BENDING WIDTH
OUTER CIRCUMFERENCE LENGTH

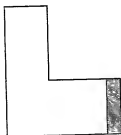
12/20
FIG.11

MOLD REMODELING INFORMATION
(FORMING APPEARANCE)

<REMODELING PATTERN>

☒ NO REMODELING

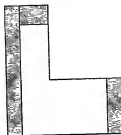
☐ A)



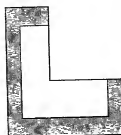
☐ B)



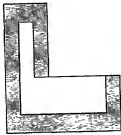
☐ C)



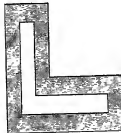
☐ D)



☐ E)



☐ F)



ENLARGING SIZE



REDUCING SIZE

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10029270.122801

13/20
FIG.12

MOLD REMODELING INFORMATION (BOX-SHARE
BENDING/ STAIR-LIKE BENDING

No.	TYPE OF REMODELING	NUMBER OF POINTS TO BE REMODELED
1	[STAIR-LIKE SHAPING] HEIGHTENING BENDING HEIGHT	2

<REMODELING PATTERN>

- ☐ [BOX-SHAPE BENDING] CHANGING BENDING HEIGHT
OR CHANGING BENDING POSITION
- ☒ [STAIR-LIKE BENDING] HEIGHTENING BENDING HEIGHT
- ☐ [STAIR-LIKE BENDING] LOWERING BENDING HEIGHT
- ☐ UNBENDING

2

NEW

UPLOAD

DELETE

10029270.122801

FIG. 13

MOLD REMODELING INFORMATION (PUNCHING)

No.	KIND OF HOLE	PUNCHING DIAMETER	NUMBER OF POINTS TO BE PUNCHED	TYPE OF REMODELING	DUPLICATION
No.	CIRCULAR HOLE	5.00	1	NEWLY ADDING HOLE	DUPLICATED
No.	CIRCULAR HOLE	5.00	1	CHANGING HOLE DIAMETER (LARGE→SMALL)	NON

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HOLE DIAMETER (SIZE AFTER REMODELING)


3.00


NUMBER OF POINTS TO BE PUNCHED

1

(SHAPE OF HOLE)


 RECTANGULAR HOLE


 CIRCULAR HOLE


 PENTAGONAL HOLE

(REMODELING PATTERN)

☐ NEWLY ADDING HOLE

☒ CHANGING HOLE DIAMETER

☐ CHANGING HOLE POSITION (LARGE→SMALL)

HOLES

☐ DUPLICATED
 ☒ NO DUPLICATION

DELETE

UPLOAD

NEW

15/20

FIG.14

PROCESSING COST INFORMATION

UNIT PRICE
OF
COMPONENT

0.00 YEN →

PROCESSING
COST

0.00 YEN →

COMPUTED UNIT
PRICE OF
COMPONENT

0.00 YEN

COMPUTED
PROCESSING
COST

0.00 YEN

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KIND OF SURFACE TREATMENT

chNi	▼	
Ni		
Zn		
CrN		
....		

0.000 μ m

86.100 mm

0.000 mm

10029270-122801

16/20

FIG.15

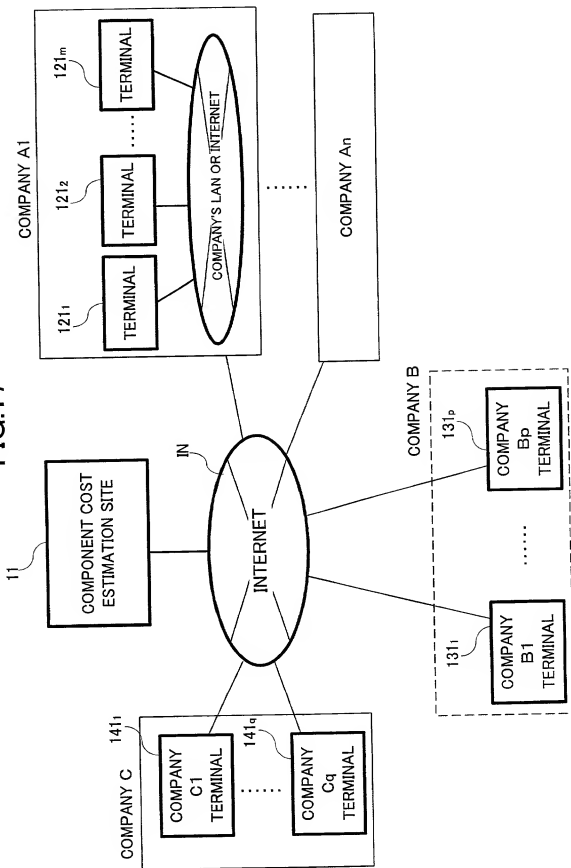
PRESS						
CODE NUMBER	SUFFIX	GUIDING PLATE: SHEET DELIVERY TOP				
KIND	NAME OF COMPONENT	MENU				
UNIT PRICE OF COMPONENT MATERIAL EXPENSE 10.481 YEN (CHILD COMPONENT COST) 0 YEN MANUFACTURING COST 14.81 YEN PRIMARY MANUFACTURING COST 10.81 YEN COST 10.86 YEN SECONDARY MANUFACTURING COST 0 YEN OTHERS		MANUFACTURING STEP INFORMATION				
(MOLD COST DATA) SUM TOTAL 173,561.561 YEN COMPUTATION OF SUM TOTAL ◎NOT USE ◎TYPICAL MOLD ◎MASTER DIE SET TYPE MOLD		CHILD COMPONENT INFORMATION				
(BASIC DATA) MONTHLY LOT 400 LOTS/MONTH TOTAL LOT 1234 LOTS MATERIAL CODE 2P1 LIST MATERIAL NAME SPC SE BOARD THICKNESS mm MATERIAL FORM PLATE MATERIAL SECURE NUMBER 1 EXTEND LENGTH 250 mm EXTEND WIDTH 40 mm OUTER CIRCUMFERENCE LENGTH mm		PROCESSING COST INFORMATION				
(MANUFACTURING STEP INFORMATION) NO. NAME OF MANUFACTURING STEP DESIGNATED COST CENTER MANUFACTURING COST MOLD COST REMODEL		COMPUTATION OF MATERIAL HANDLING COST				
1	APPROXIMATE PUNCHING	PRESS901	4.85	764.98	LIST OF COM- PONENTS FOR COST COM- PUTATION	
2	BOX SHAPE BENDING	PRESS801	6.76	654.265		
3	BOX SHAPE BENDING	PRESS701	6.76	364.321		
4	BEAD	PRESS601	6.49	645.312		
<input type="checkbox"/> COMPONENT HARD TO HANDLE					LIST OF MOLDS FOR COST COM- PUTATION	

☐ READ ☐ REGISTER ☐ COMPUTE ☐ ALL CLEAR ☐ ALL CLEAR ☐ COMPUTATION RESERVE

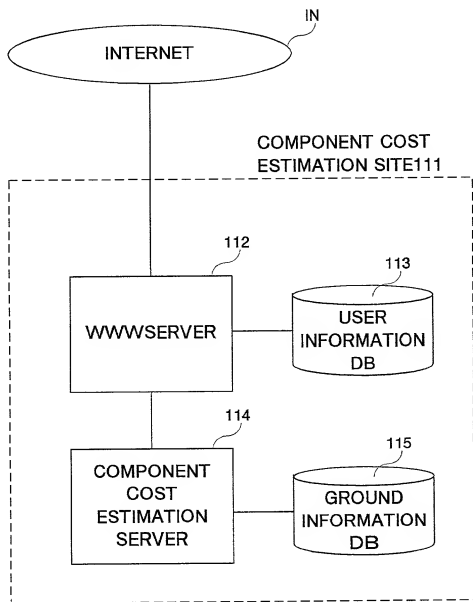
FIG. 16

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18/20



19/20
FIG.18



10029270.122801

20/20

FIG.19

LOGIN

ID

PASSWORD

10029270.122801